

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009422**Date Inspected:** 27-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua/Shen Fu You**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

This QA inspector observed the following work in progress:

Bay#1

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(CW002A-PP100-002, 003, 008)

-(CW002A-PP100-004, 020, 023, 019, 020)

-(CW002A-PP102-002, 003, 008)

-(CW002B-PP102-020, 023, 019, 021)

-(CW002B-PP102-004, 007, 008, 015)

-(CW002A-PP088-001, 004)

-(CW002-PP088-127, 132, 133)

Bay#2

During random visual inspection, this QA inspector observed two transverse linear indications found my ABFJV MT inspectors, on floor beam weld joints, FB3030-003-002, 004. For further information please find attached pictures below.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Segment8AE

SMAW welding of weld joint CA048-016, 012, 008 located on Segment 8AE. Welder is identified as 204339 (3F). ZPMC QC is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2113-FCM-1.

SMAW welding of weld joint CA048-009, 013, 017 located on Segment 8AE. Welder is identified as 216086 (2F). ZPMC QC is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2112-FCM-1.

SMAW welding of weld joint CA048-007, 010, 011, 014, 015, 018 located on Segment 8AE. Welder is identified as 216086 (2G). ZPMC QC is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

Bay#14

SAW welding of weld joint Seg063*-007 located on Segment 10CW. Welder is identified as 045265 (1G). ZPMC QC is identified as Liu Wan Ning. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

FCAW welding of weld joint Seg074A-003 located on Segment 11EE. Welder is identified as 214945(1G). ZPMC QC is identified as Liu Wan Ning. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U2-F.

Segment8AW

SMAW welding of weld joint Seg043D-066, 067 located on Segment 8AW. Welder is identified as 037942 (4F). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

SMAW welding of weld joint Seg043D-151 located on Segment 8AW. Welder is identified as 044772(3G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-F.

FCAW welding of weld joint Seg043E-030, 039 located on Segment 8AW. Welder is identified as 066683 (3G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

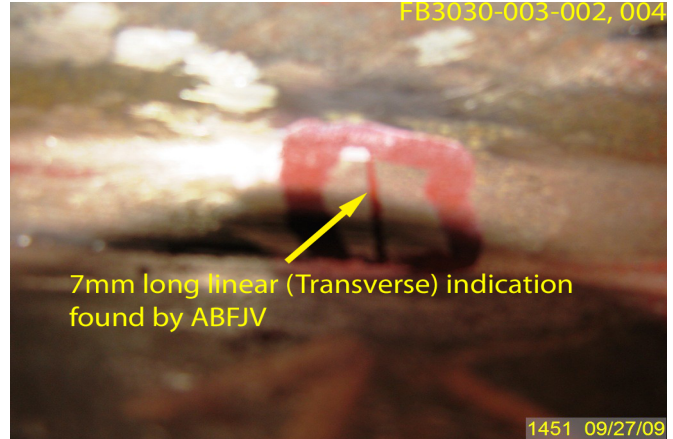
WELDING INSPECTION REPORT

(Continued Page 3 of 3)

FB3030-003-002



FB3030-003-002, 004



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
